

Date: Tuesday, 4/18/2006 10:06:47 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: DOUBLER
Job Number	: 26688		
Estimate Number	: 11318		
P.O. Number	: N/A	Part Number	: D33023
This Issue	: 4/18/2006 S.O. No. : N/A	Drawing Number	: D3302 REV B2
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: B2
Previous Run	: N/A	Material	: N/A
Written By	: SEE COMMENT BELOW	Due Date	: 5/5/2006
Checked & Approved By	: JH 06-04-18	Qty:	10 Um: Each
Comment	: Est A 04.09.02 New issue KJ/JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6S063	6061-T6 .063 Sheet
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Comment: Qty.: 1.0428 sf(s)/Unit Total: 10.4276 sf(s)
 6061-T6 .063 Sheet
 Material: 6061-T6 (QQ-A-250/11) 0.063" thick
 (M6061T6S.063)
 Identify for D3302-3
 Batch: M19556

2.0	SHEAR	SHEAR
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Comment: SHEAR
 Cut blank: 14.550" x 9.100"

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per Folio FA460 and Dwg D3302
 Stack of 10
 Identify as D3302-3

Cut

preg. Rev. B2

Dwg Rev. B2

M/06.05.02 (10)

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BL/M/06.05.02 (10)

5.0	QC8	SECOND CHECK
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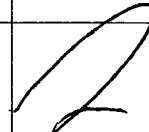
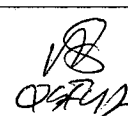
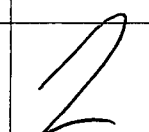


Comment: SECOND CHECK

JH 06.05.03 (10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/05/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-05-08	5.0	4 parts missing from water set to inspection rack. No split had been made...		Qty 6 remaining on w/o. Rest in water jet Scrap 4 other 4 are untraceable & P# in product.		 06-05-08		 06-05-08

NOTE: Date & initial all entries

Date: Tuesday, 4/18/2006 10:06:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DOUBLER

Job Number: 26688

Part Number: D33023

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr break all unmarked sharp edges 0.005 to 0.010

MF 06-05-08 (6)

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3302

SB 06/05/11 (6)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-05-12 (6)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06-05-12 (6)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-05-13 (6)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 3fu

06/07/16 (6)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/05/17 (6)

Job Completion



06-05-17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 26688
Description: Doubler		Part Number: D3302-3
Inspection Dwg: D3302	Rev: B2	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
14.452	+/-0.010					
12.50	+/-0.030					
0.851	+/-0.010					
0.851	+/-0.010					
8.997	+/-0.010					
7.30	+/-0.030					
5.000	+/-0.005					
1.000 pitch	+/-0.005					
R0.12	+/-0.030					
1.031	+/-0.010					
2.021	+/-0.010					
1.101	+/-0.010					
11.250	+/-0.005					
1.125 pitch	+/-0.005					
1.476	+/-0.010					
7.101	+/-0.010					
0.069	+/-0.010					
Ø0.098	+0.005/-0.000					
12.750	± 0.03	12.752	✓		height gauge	
14.452	± 0.01	14.455	✓		"	
7.25	± 0.03	7.256	✓		"	
8.952	± 0.01	8.960	✓		"	
R.170	± 0.03	R.170	✓		"	

Measured by: <i>[Signature]</i>
Date: 06.05.02

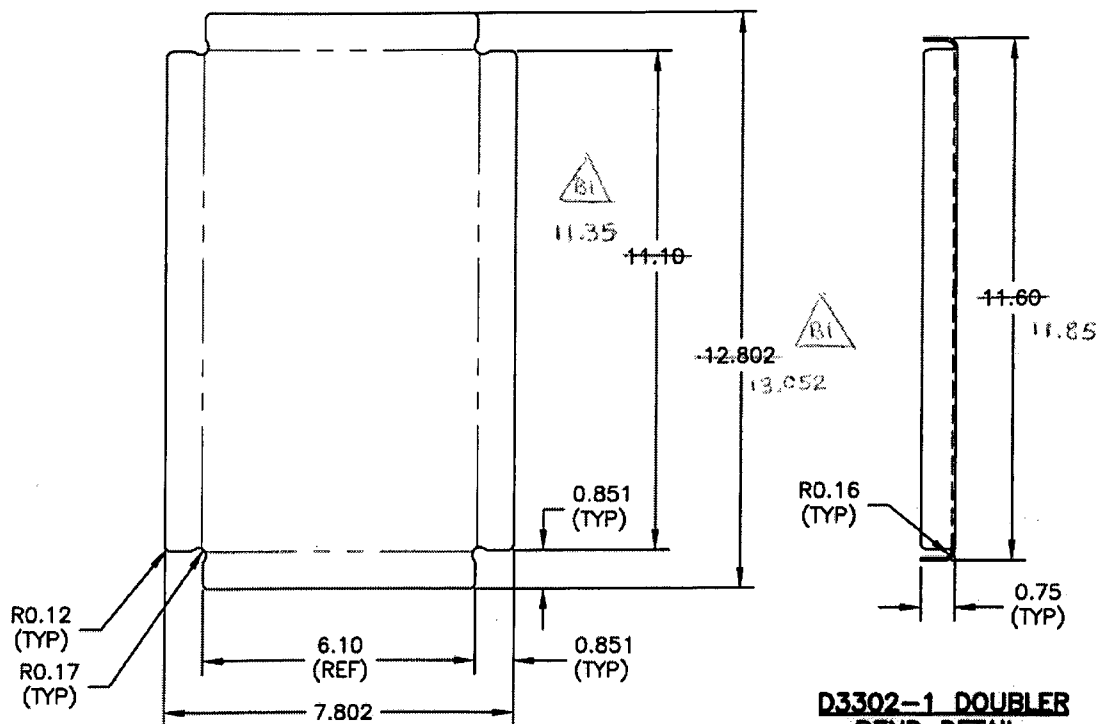
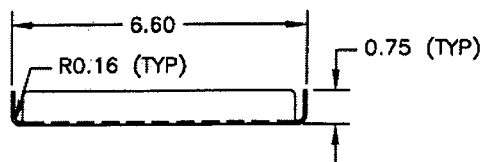
Audited by: <i>[Signature]</i>
Date: 06.05.03

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.09.03	New Issue	KJ/JLM	
B	06.03.09	Dwg Rev update; Dimensions revised to revision B2	KJ/JLM <i>[Signature]</i>	<i>[Signature]</i>

DART

DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3302	REV. B SHEET 1 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4
A	04.07.06	NEW ISSUE	
B	04.11.18	REMOVE HOLES	
B1	RF 04.12.15	ADDED 0.25" TO THE LENGTH FOR -1/-3	
B2	RF 05.03.21	7.25 WAS 7.34; 8.952 WAS 9.042; 7.75 WAS 7.84 FOR D3302-3	

RELEASED
04.11.23**D3302-1 FLAT PATTERN****D3302-1 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

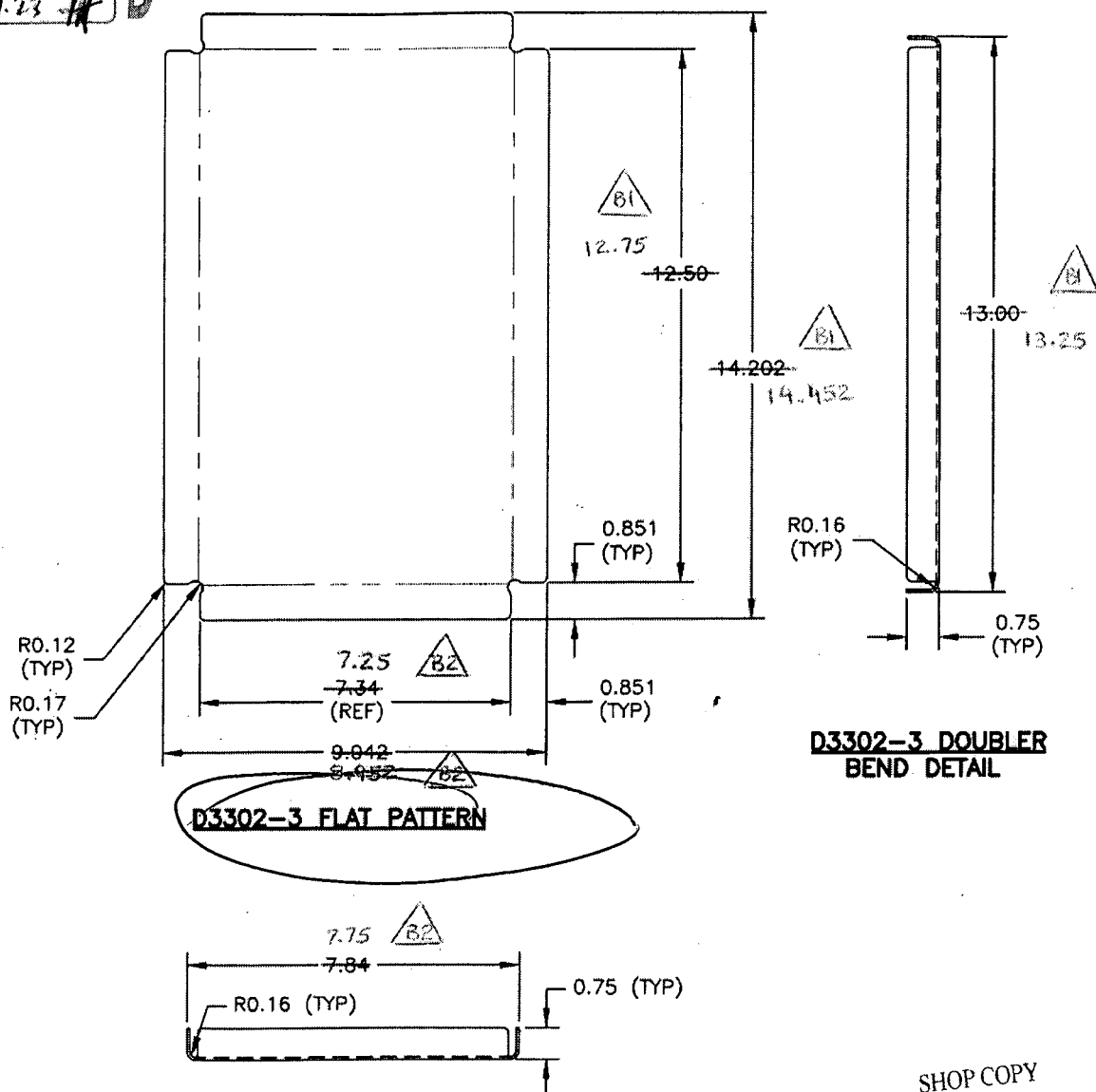
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3302	REV. B SHEET 2 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:4

RELEASED
04.11.23 *[Signature]***D3302-3 NOTES:**

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S1063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & BATCH USING FINE POINT PERMANENT MARKER

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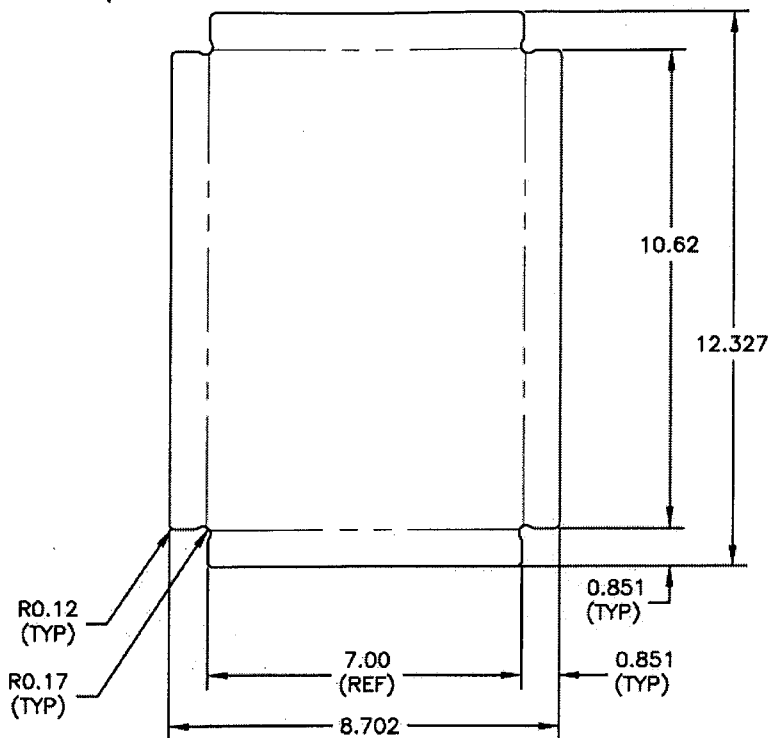
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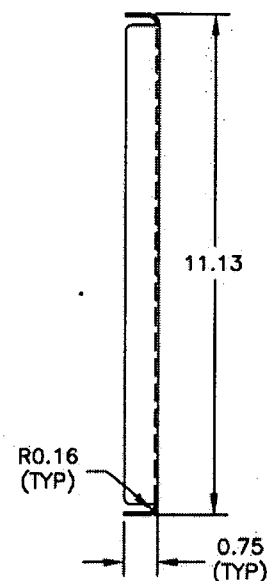


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DATE 04.11.08		TITLE DOUBLER	SCALE 1:4

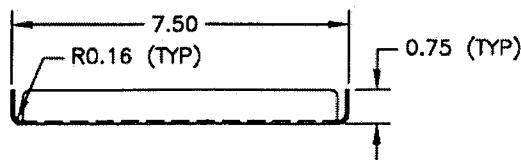
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04.11.23 H



D3302-5 FLAT PATTERN



**D3302-5 DOUBLER
BEND DETAIL**



D3302-5 NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-250/11) 0.063 THICK (REF. DART SPEC. M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

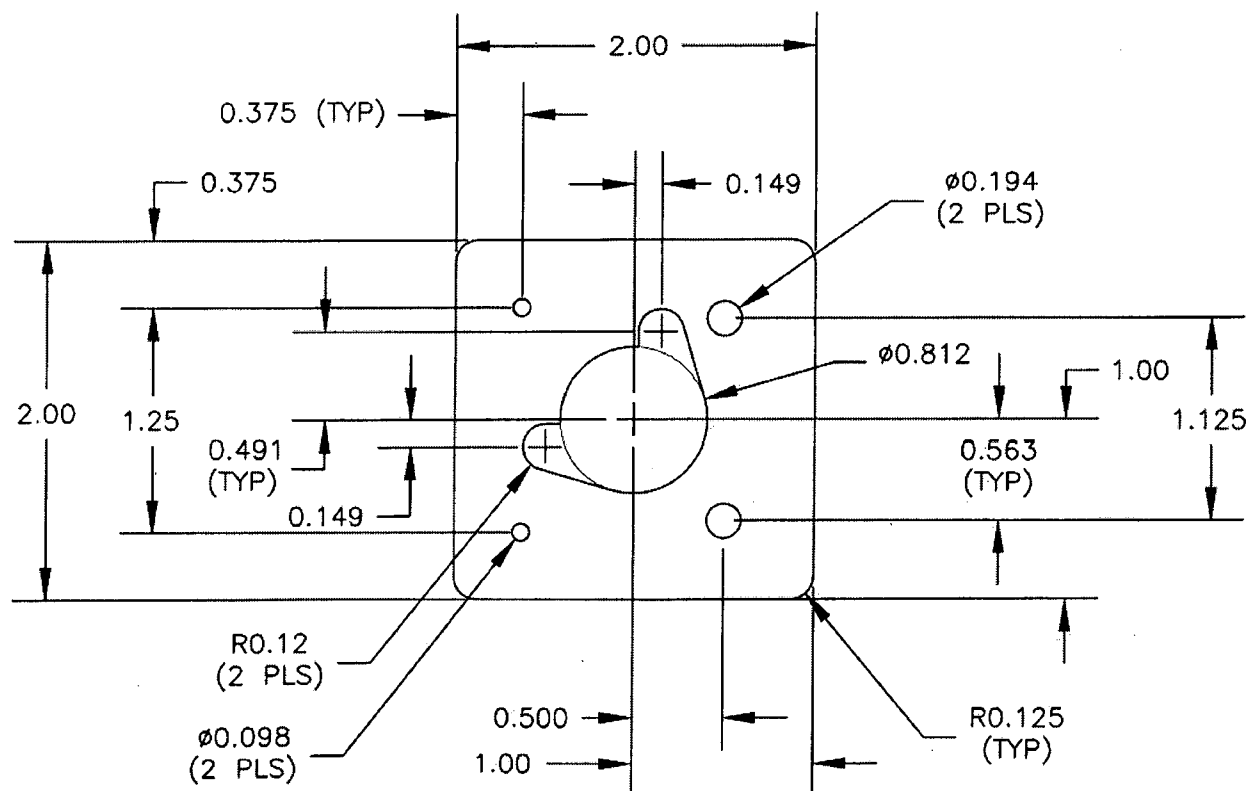
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CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3302	REV. B SHEET 4 OF 4
DATE 04.11.18		TITLE DOUBLER	SCALE 1:1

RELEASED
04.11.23 [Signature]**D3302-7****D3302-7 NOTES:**

- 1) MATERIAL: 5052-H32 OR 6061-T6 (QQ-A-250/8 OR QQ-A-250/11) 0.040 THICK (REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT MARKER

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